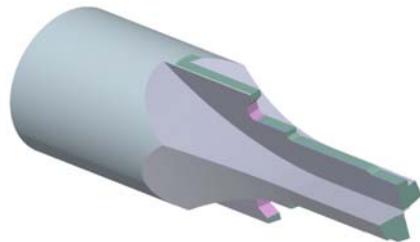


Form Reamer for fittings

A15-210

Form Reamers for fittings made of roughly braised Carbide with overmeasure of up to 8 mm are ground in one setup if the A-Axis is a fast rotating axis. The radial clearance angle in the pocket is linearly interpolated when moving from the outer towards the inner diameter. No additional clearance operations are then necessary inside the pocket profile.



1. Cycletime for Production

Tool specifications

Diameter 32 mm, Z 2, Length of cutting edge 56 mm

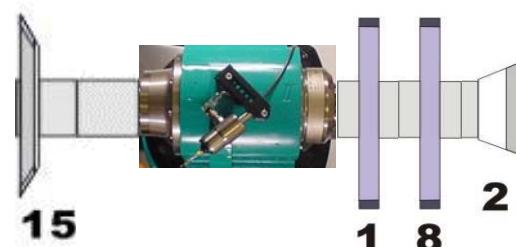
Material CARBIDE

Operations	Probe	Flute 1	Flute 2	Prf Rough	Prf Pregr	Prf fin	Pocket pregr	Pocket fin	Prf Cyl
Feed [mm/Min]	2000	35	150	7	15	65	7	25	15
Power [kW]		4	2	1	1	1	1	1	1
Cutting feed [m/s]		18	16	24	24	24	24	24	24
Used wheels									
Grinding time [s]	37	221	53	1022	483	120	307	88	483
Total cycle time	46 Min 53								

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

- 1 Ø125 1A1 D64
- 2 Ø75 11V9 D76
- 15 Ø125 1V1 V25 D46
- 8 Ø125 1A1 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR, NORMA CFG
 Control: Fanuc 31i
 Coolant: Synthetic Oil, pressure 6 - 7 bar
 Software: Quinto 5

responsible engineer: OP,5.2.08

www.schneeberger.ch

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TECHNOLOGY
FOR TOOLING